

AS

Work Order ID 116781

116781

Page 1

April-24-14 7:38:50 AM

Item ID: D3793-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Aft
Start Date: 4/23/14 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 4/23/14 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: MJS Date: 4-24-14 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100	FLOW WATER JET	0.00							DAS 23 9-89 14-07-5
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100

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89 14-07-5
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110

QC

Memo

Quality Control

120	QC8- Inspect parts - second check	0.00							
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120

QC

Memo

Quality Control

SMB
14/7/7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

0.00

0.00

DAS
30
9-89

12

14607/03

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SW
4/7/8

10

150

150

Powdercoat

Powder Coating

Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3

Memo

START TIME: 12:00

OVEN TEMPERATURE: 320

FINISH TIME: 12:30

0.00

0.00

12 d M-79

DAS
34
9-89

DQA: _____ Date: _____



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160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				12			
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>EP-002</u> Memo	0.00 0.00				x12			
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5	14-07-09		

unc
14-7-09

DQA: _____ Date: _____



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NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART PIN "DXXXX-X" ON INSIDE SURFACE USING FINE POINT
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE		PH	08.05.14
REV.		DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA		
DRAWN	PH			
CHECKED			DRAWING NO.	REV. A
MFG. APPR.	PH		D3793	SHEET 1 OF 2
APPROVED	PH		TITLE	SCALE
DE APPR.	PH	WEARSHOE		NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		